



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 180494



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/7/18

Job Tracking No: NOT AIRBUS

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Large Fab-4		SLH
110	Large Fab	1 pcs	8/3/18	8/3/18	0.00	0.99	Large Fab 2		CPC
120	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC9		SLH
130	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC5		SA 18-07-24
140	HandFinish	1 pcs	8/3/18	8/3/18	0.00	0.18	HandFinish1		CPC
150	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC7-2		CML
180	Large Fab	1 pcs	8/3/18	8/3/18	0.00	0.99	Large Fab 2		SA 18-07-24
190	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC10		SA 18-07-27
200	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC5		SA 18-07-30
210	HandFinish	1 pcs	8/3/18	8/3/18	0.00	0.18	HandFinish1		SA 18-07-31
220	Powdercoat	1 pcs	8/3/18	8/3/18	0.00	0.29	Powdercoat1		BE 18-07-31
230	HandFinish	1 pcs	8/3/18	8/3/18	0.00	0.18	HandFinish3		SA 18-08-01
240	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC3		SA 18-08-01
250	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging1-3		SA 18-08-01
260	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC4		SA 18-08-01
270	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-1		SA 18-08-01
275	DC	1 pcs	8/3/18	8/3/18	0.00	0.00	DC		SA 18-08-01
280	QC21-FG	1 Ea	8/3/18	8/3/18	0.00	0.00	QC21		SA 18-08-01

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod MB4785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod MB4785 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 8:15am OVEN TEMPERATURE: 320°F FINISH TIME: 8:45pm

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Wing Walk MB8851

004654

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	5069554
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	5053126
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5091618
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	5094055

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	133	0
	D3219-1	2	123	0
	D3272-1	1	25	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	178	0
	MS20600-AD4W4	16	3,204	0
250-Packaging	AN3-35A	2	380	0
	AN4-13A	8	2,267	0
	AN5-36A	2	324	0
	D2230-3	4	333	0
	D2618	2	208	0
	D2856-400-720	2	74	0
	D3235-1	2	273	0
	D3278-041	1	42	0
	MS21042L3	2	2,098	0
	MS21042L4	8	3,264	0
	MS21042L5	2	922	0
	NAS1149D0363J	4	1,624	0
	NAS1149D0463J	16	7,333	0
	NAS1149D0563J	4	1,638	0

Part Specifications

rt.lajeunesse.marie

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S091937

Part: D350-591-311

Job No: 180494

Serial No/Batch: S091937

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/16/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311

Job Sheet 180494



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/7/18

Job Tracking No: NOT AIRBUS

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/3/18	0.00	0.00	Start Up Large Fab-4		AUG 01 2018
110	Large Fab	1 pcs		8/3/18	0.00	0.99	Large Fab 2		
120	QC	1 pcs		8/3/18	0.00	0.00	QC9		CPL
130	QC	1 pcs		8/3/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		8/3/18	0.00	0.18	HandFinish1		SA 15-07-24
150	QC	1 pcs		8/3/18	0.00	0.00	QC7-2		
180	Large Fab	1 pcs		8/3/18	0.00	0.99	Large Fab 2		CPL
190	QC	1 pcs		8/3/18	0.00	0.00	QC10		
200	QC	1 pcs		8/3/18	0.00	0.00	QC5		SA 18-07-23
210	HandFinish	1 pcs		8/3/18	0.00	0.18	HandFinish1		
220	Powdercoat	1 pcs		8/3/18	0.00	0.29	Powdercoat1		SA 18-07-30
230	HandFinish	1 pcs		8/3/18	0.00	0.18	HandFinish3		
240	QC	1 pcs		8/3/18	0.00	0.00	QC3		BEB 18-07-31
250	Packaging	1 pcs		8/3/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		8/3/18	0.00	0.00	QC4		CPL
270	Packaging	1 pcs		8/3/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs		8/3/18	0.00	0.00	DC		
280	QC21-FG	1 Ea		8/3/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 8:15am OVEN TEMPERATURE: 320°F FINISH TIME: 8:40am

270 - Identify and pack for shipping as per PPPD350-591-311 Location: FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	

004703

1

D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

3089307
3089302
3071348
302553
3082275
3092667
309615
3092091
3089340
3089365
3058178
3068661
3089299
3093773
3081331

DSI 9410-011

1ea

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	133	0
	D3219-1	2	123	0
	D3272-1	1	25	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	178	0
250-Packaging	MS20600-AD4W4	16	3,204	0
	AN3-35A	2	380	0
	AN4-13A	8	2,267	0
	AN5-36A	2	324	0
	D2230-3	4	333	0
	D2618	2	208	0
	D2856-400-720	2	74	0
	D3235-1	2	273	0
	D3278-041	1	42	0
	MS21042L3	2	2,098	0
	MS21042L4	8	3,264	0
	MS21042L5	2	922	0
	NAS1149D0363J	4	1,624	0
	NAS1149D0463J	16	7,333	0
	NAS1149D0563J	4	1,638	0

DSI 9410-011 X1

Part Specifications

rt.lajeunesse.marie

Unit response Ltd.
1270 Aberdeen Street
Brampton, ON K6A 1K7
CANADA
TEL: 1 513 632-5200
Email: sales@unitresponse.com
www.unitresponse.com

Date: 07/16/18

PART

AEROSPACE

Container No: S091937



Part: D350-591-311

Job No: 180494

Serial No/Batch: S091937

Revision:

Inspector:

Exp Date:

Instructions:



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004803	S098343	AN3-35A	Bolt	S089307	ST348	2
004803	S098340	AN4-13A	Bolt	S089302	OVER003	8
004803	S098339	AN5-36A	Bolt	S071345	ST336	2
004803	S098338	D2618	Bushing	S082275	ST008	2
004803	S098337	D2856-400-720	Abrasion Strip 4" X 7.20"	S092667	ST418	2
004803	S098335	D3235-1	Mounting Lug	S089615	ST522	2
004803	S098333	D3278-041	Support Assembly	S092091	ST522	1
004803	S081331	DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	S081326	FG123	1
004803	S098331	MS21042L3	Nut	S089340	ST303	2
004803	S098330	MS21042L4	Nut	S089365	ST303	8
004803	S098328	MS21042L5	Nut	S058178	ST303	2
004803	S098327	NAS1149D0363J	Washer	S068661	ST263	4
004803	S098325	NAS1149D0463J	Washer	S089299	ST263	16
004803	S098324	NAS1149D0563J	Washer	S093773	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 8/1/18 1:44 PM Dart.joly.jocelyne

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY